Dart Aerospace Ltd. Friday, 9/29/2006 10:44:12 AM Date: Kim Johnston User: **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : CROSSBOLT SPACER Customer Job Number : 28801 : 10993 **Estimate Number** : D2579 P.O. Number : NIA **Part Number** S.O. No. : 1/1A : D2579 REV D : 9/29/2006 **Drawing Number** This Issue : NC Project Number : N/A Prsht Rev. : NA : MACHINED PARTS : D Type First Issue **Drawing Revision** :NA : 27921 Material **Previous Run** : 10/12/2006 500 Um: Each **Due Date** Qty: Written By Checked & Approved By NG : Est E Now turned on Cobra Comment **Additional Product** Job Number: Machine Or Operation: Description: Seq. #: M6061T6T0500W058 6061-T6 Tube .500 x.058W 1.0 Comment: Qty.: 0.3762 f(s)/Unit Total: 188.1075 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 06/10/10 Batch M 102056 0.500 Dia x 0.058 Wall HARDINGE CNC LATHE SMALL 2.0 **HARDINGE** Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA245 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 Comment: SECOND CHECK 500 5.0 PACKAGING 1 PACKAGING RESOURCE #1

Page 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

PB06/10/18

Dart Aerospace Ltd

W /O:		WORK ORDER CH					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	N) DQ	A :	_ Date: _ <u></u>	SUINB
			QA:	N/C Close		_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Verification	A1	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
							,	ť		

NOTE: Date & initial all entries

Date:

Friday, 9/29/2006 10:44:12 AM

Ûser:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 28801

Job Number:

Seq. #:

Machine Or Operation:

Description:

Part Number: D2579

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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Dart Ae	rospace	e Lta							
W/O:			WC	RK ORDER CHANGES				,	
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory: N	ICR: Yes	No DQ	A:	Date:	
					QA: N	/C Close	d:	_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCF	l)			
DATE	December	Description of NC	Corrective Action Section			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Section C	Chief Eng	QC Inspector
	•					,			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28801
Description: Cross Bolt Spacer	Part Number:	D2579
Inspection Dwg: D2579 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First Ar	ticle	Prot	otype
Drawing	Tolerance	Actual	Accept	Reject	Method

Drawing	Drawing Tolerance Dimension		Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	4.07 /			•	
0.058	+/-0.010	0,057	/			
		0,057				
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			-			
			·			

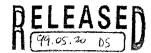
Measured by:	A	Audited by:	MS	Prototype Approval:	N/A
Date:	66/10/16	Date:	06/10/16	Date:	NIA

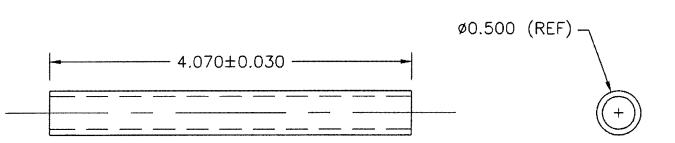
Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROYED	DRAWING NO. REV. D
-##-	I AE	D2579 SHEET 1 OF 1
DATE		TITLE SCALE
99.05.19		CROSS BOLT SPACER 1:1
Α.	96.09.16	NEW ISSUE
В	96.12.05	0.065 WALL WAS 0.035 WALL
С	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)





MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-706H0F)OPY

0.500 DIA x 0.058 WALL

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTENGINEERING

UNCONTROLLED COP

SUBJECT TO AMENDMENT

WITHOUT NOTICE

NO. 28 SEE